

Date: Wednesday, 10/09/2008 1:52:44 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PIN
Job Number	: 41930		
Estimate Number	: 12672		
P.O. Number	:	Part Number	: D31471
This Issue	: 10/09/2008 S.O. No. :	Drawing Number	: D3147 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 41616	Material	:
Written By	:	Due Date	: 10/05/2008 Qty: 20 Um: Each
Checked & Approved By	: <u>JLD 08.9.10</u>		
Comment	: Est Rev A New Issue 07-01-26 JLM Est Rev:B Now on Cnc 07-05-02 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M303R0187	303 Round Bar 0.187"
-----	-----------	----------------------



Comment: Qty.: 0.2363 f(s)/Unit Total: 4.7250 f(s)

303 Round Bar 0.187"

Batch: M105341

J.F. 08/10/14 (21)

2.0	HARDINGE <u>DOOSAN</u> HARDINGE CNC LATHE SMALL
-----	--



Comment: 1-TURN AS PER FOLIO FA691 & DWG D3147,

FOLIO REV: CDWG REV: C

2-DEBURR AS REQUIRED

J.F. 08/10/14 (21)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/10/14 (21)

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA691 Rev: _____ & Dwg D3147 Rev: _____

2-Deburr per dwg D3443

N/A 08-10-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/09/2008 1:52:44 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIN

Job Number: 41930

Part Number: D31471

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 69

8/10/15

SLP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

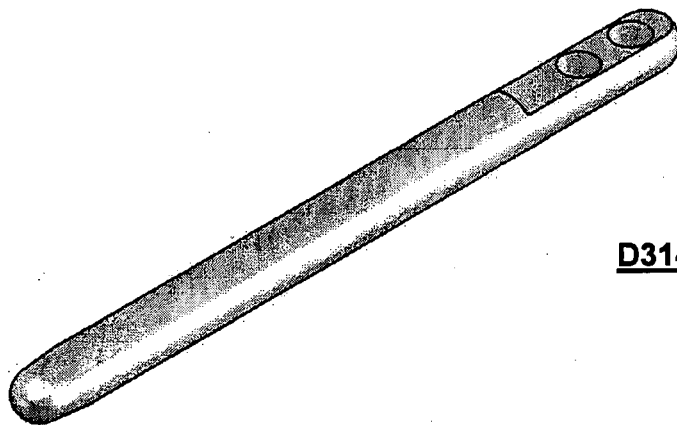
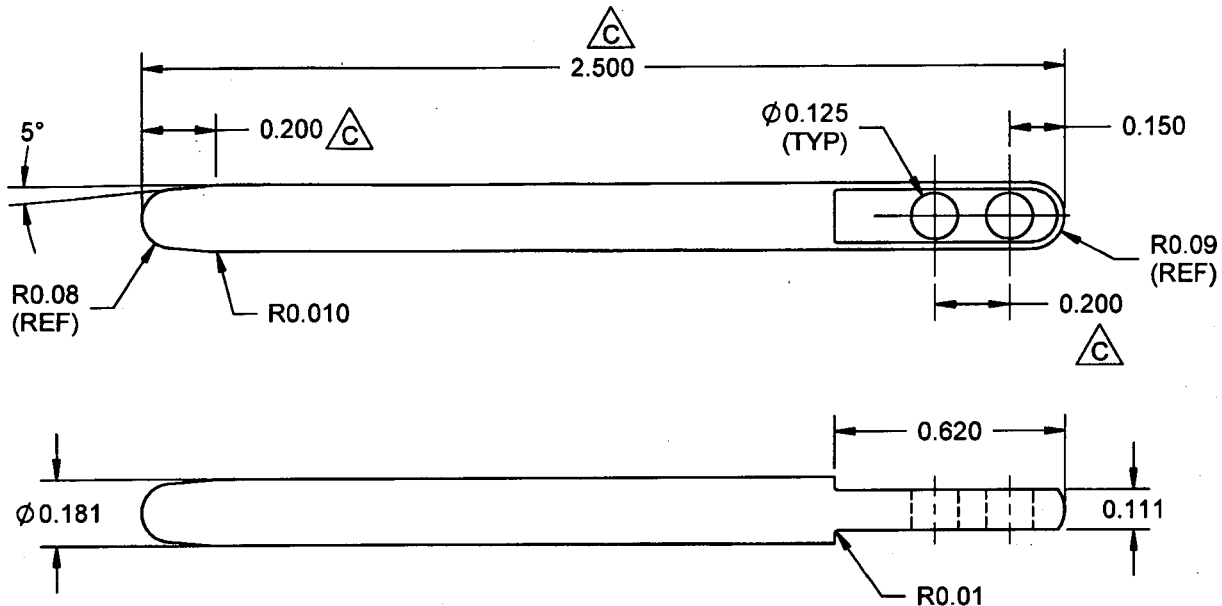
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY J. J. H.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED J. J. H.	DRAWING NO. D3147	REV. C SHEET 1 OF 1
DATE 06.12.04	TITLE PIN SCALE 2:1		
REV	DATE	DESCRIPTION	
A	02.04.23	NEW ISSUE	
B	04.10.18	ADD PART MARKING AND NORMALIZED	
C	06.12.04	ADD SECOND Ø0.125 HOLE; CHANGE MATERIAL; 0.200 TAPER WAS 0.400; REMOVE SUPPLIER AND FINISHING	



D3147-1 PIN

RELEASED

07-01-22

NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR (REF DART SPEC M303R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3147-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015 MAX
- 7) REPLACES PREMIER P/N B30-23000-119

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4930

COPYRIGHT © 2002 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.